PLR-22 Pistol
SU-22 Rifle

KEL-TEC CNC INDUSTRIES INC.

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"THE USE OF A LOCKING DEVICE OR SAFETY LOCK IS ONLY ONE ASPECT OF RESPONSIBLE FIREARM STOARAGE. FIREARMS SHOULD BE STORED UNLOADED AND LOCKED IN A LOCATION THAT IS BOTH SEPARATE FROM THEIR AMMUNITION AND INACCESSIBLE TO CHILDREN AND OTHER UNAUTHORIZED PERSONS."

SAFETY, INSTRUCTION, AND PARTS MANUAL

KEL-TEC PLR-22 Pistol and SU-22 Rifle

SAFETY, INSTRUCTION & PARTS MANUAL

STATEMENT OF LIABILITY

This firearm may be classified as a dangerous weapon and is surrendered by KEL-TEC CNC INDUSTRIES INC. with the understanding that the purchaser assumes all liability resulting from unsafe handling or any action that constitutes a violation of any applicable laws or regulations. Firearms can cause serious injury and death. Safety must be the prime consideration of anyone who handles firearms. Always treat a firearm as though it were loaded. Always keep the muzzle pointed in a safe direction.

In owning a firearm, you are responsible for the firearm's safety and security. Always secure firearms from children.

READ THESE INSTRUCTIONS AND WARNINGS CAREFULLY, BE SURE YOU UNDERSTAND THESE INSTRUCTIONS AND WARNINGS BEFORE USING THIS FIREARM.

This SAFETY, INSTRUCTION & PARTS MANUAL should always accompany this firearm and be transferred with it upon change of ownership or when the firearm is loaned or presented to another person. A copy of the SAFETY, INSTRUCTION & PARTS MANUAL is available FREE upon request and can also be downloaded from the internet at: http://www.kel-tec-cnc.com.

READ AND CAREFULLY FOLLOW THESE WARNINGS AND INSTRUCTIONS

These warnings and instructions are provided to assure the safe functioning of the firearm. Failure to heed them may result in improper functioning and serious injury.

Kel-Tec firearms are designed to function reliably with proper care and knowledgeable use. Do not use your firearm unless you fully understand these instructions, and the safe operation of your firearm.

Only safe gun-handling habits will ensure the safe use of your firearm. This is your responsibility. Accidents are the result of violating the rules of safe gun handling noted below and common sense.

Before handling a firearm, understand its operation.

Never accept or pick up a firearm without checking the magazine and the chamber to assure the weapon is empty. Do not trust the extractor to clear the chamber, always look and feel.

Always make sure the muzzle is pointed in a safe direction at all times.

Never point a firearm at anyone or anything you do not intend to shoot.

Make sure your “audience” is always 5 feet behind you, not next to you when firing.

Keep your firearm unloaded when not in use.

Never keep a loaded firearm in the home or vehicle. Never store a firearm with a cartridge in the chamber.

Never store firearms and ammunition together, keep them locked up and away from children.

Never touch the trigger when working the action. Never alter any components of your firearm.

Never take medications, drugs, or alcohol when handling firearms.

Never load or unload a firearm without assuring the muzzle is pointed in a safe direction.

Never load a firearm except immediately before shooting.

SAFE GUN HANDLING IS YOUR RESPONSIBILITY

The PLR-22 pistol and SU-22 rifle are designed and chambered for the .22 Long Rifle (.22LR) cartridge. The type of ammunition is also stated on the right side of the receiver. Do not use any other ammunition.

Only use commercially manufactured ammunition, clean, dry, and in good condition. Never use non-standard, reloaded or damaged cartridges.

Never use ammunition where the pressure levels exceed industry standards. Kel-Tec guns are manufactured from high quality materials. They will provide extended service life. However, all warranties, expressed or implied, are voided and Kel-Tec will not be liable for property damage or personal injury and consequential damages, if faulty ammunition is used in Kel-Tec firearms.

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

Never discharge a firearm without proper shooting glasses and ear protection. Never shoot at any water surface or any surface where a ricochet can occur.

Never shoot until you are sure of your backstop and what lies beyond it.

If the gun does not discharge after pulling the trigger, do not change its direction for at least 30 seconds, you could be having a “hang fire”.

Do not allow a firearm to be used by individuals who do not understand its safe operation and the rules of safe gun handling.

CAUTION: After firing several rounds the forward, exterior metal parts of the firearm get hot and can cause severe burns.

Be sure all accessories are compatible with the firearm and that the accessories do not interfere with safe operation.

When transporting your firearm, be sure your firearm is unloaded.

If you do not understand how to operate any of our products or have any questions about their safe handling, please write, call, or email us.

Always be aware of other people so that they cannot accidentally walk into the line of fire. When firing on a target range, be alert and follow the range officer’s commands. Never cross obstacles such as fences or streams with a loaded firearm.

INTRODUCTION

The PLR-22 pistol and SU-22 rifle are semi-automatic firearms chambered for the .22 Long Rifle (.22LR) cartridge. They will accept most standard Atchison style M-16 .22LR conversion magazines.

CONSTRUCTION

The receiver and grip are made of an impact resistant glass reinforced Zytel. The receiver has a metal insert molded into the front to accept the barrel and the serial number. A MIL-STD-1913 picatinny rail is integrated into the top of the receiver to allow for attachments.

The firing mechanism is of conventional single action type. It has a push bolt safety that blocks the trigger. The muzzle end of the barrel is threaded with a 1/2-28 inch thread to accept standard attachments such as a muzzle brake. With the firearm unloaded, chamber clear, and safety on, simply unscrew the knurled thread protector to expose the thread. Apply no more than 20 ft-lbs of torque to these threads.

INSTRUCTIONS FOR USE

Safety

To achieve operator safety, combined with ease of handling, the PLR-22 pistol's and SU-22 rifle's manual safety, when applied, positively blocks the trigger from rotating the sear. The safety can be applied at any time, whether the hammer is cocked or not. Only when the red ring on the safety is fully obscured is the safety engaged.
Obviously the safest condition of the pistol is unloaded. Also considering unauthorized operation, other modes of storing or carrying will gradually improve readiness at the cost of safety.

Malfunctioning

Proper function of your firearm is directly related to maintenance and care, and to the ammunition you use. Some of the more common types of malfunctions which may occur are as follows:

Misfire: A failure to fire or an unusual sound upon firing is always a signal to cease firing and immediately examine the bore of the firearm. It is not sufficient to just pull the operating handle back and examine the chamber. You must remove the magazine, clear the chamber, lock the bolt open and inspect the bore visually - and with a rod if necessary - to be certain it is completely clear of any obstruction. Failure to detect and remove a bore obstruction can result in serious injury or death to the shooter and bystanders, as well as damage to the firearm.

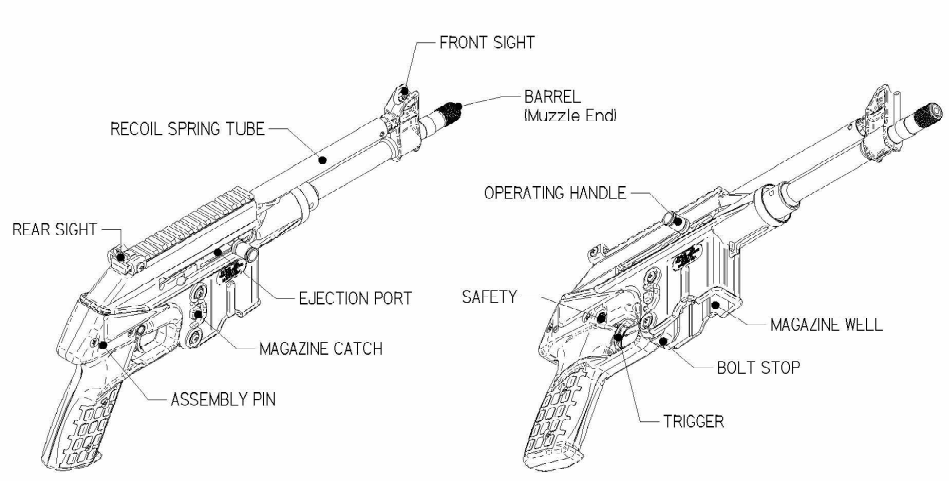
WARNING: DO NOT ATTEMPT TO REMOVE A LODGED BULLET OR ANY OTHER OBSTRUCTION BY USING A BLANK CARTRIDGE, OR A CARTRIDGE WITH THE BULLET REMOVED, OR BY ANY MEANS OTHER THAN THE USE OF THE PROPER SIZE CLEANING ROD (WITHOUT A TIP OR BRUSH) AND REASONABLE FORCE APPLIED TO THE ROD. BE CERTAIN ALL LOOSE POWDER HAS BEEN REMOVED FROM THE BORE AND ACTION BEFORE INTRODUCING THE ROD INTO THE BORE.

Failure to Feed: This occurs when a cartridge has been fed from a magazine but not fully chambered. If this occurs, keep the firearm pointed in a safe direction, lock the bolt back, remove that cartridge, release the bolt and continue shooting. If necessary, change the magazine or ammunition type. The most common causes are dirt or foreign objects impeding the magazine follower. Improperly or loosely crimped cartridges are another common cause.

Failure to Eject or Extract: A fired case is not fully extracted from the chamber or ejected from the pistol. Again, keep the firearm pointed in a safe direction, clear the gun by operating the bolt and locking it back, remove the case and continue. If necessary, change the magazine. The most common causes are a damaged extractor, ejector, or ammunition. Improperly loaded or sized cartridges can also cause this. If any of the above problems are not solved by cleaning or by use of other brands of ammunition, stop firing, unload and return the firearm to our service department.

Firing

With the muzzle pointed in a safe direction and your finger outside the trigger guard, take aim at a safe target, disengage the safety and squeeze the trigger until a round is fired. Release the trigger and you are ready to fire another round. Upon firing, the bolt moves rearward extracting and ejecting the fired round and returns to the forward position feeding another round automatically. This sequence can be repeated until the last round has been fired. The firearm does not have an automatic bolt stop so the bolt will not lock back after the last round in the magazine is fired. Lock the bolt back manually by pulling the operating handle back and holding it, then press and hold up on the bolt stop and slowly release the bolt handle. Remove the empty magazine by pressing the magazine catch located on the right side of the receiver and pull out the empty magazine. To continue shooting simply insert a full magazine into the magazine well, while holding the magazine catch in, firmly push the magazine up and release the magazine catch. The magazine should lock into place. Pull back and release the operating handle to release the bolt stop and feed the next round. The rifle is now ready to fire.



Operating controls are identical between all models of PLR-22 Pistol and SU-22 Rifle

Unloading

To unload the firearm, engage the safety, push in the magazine catch, remove the magazine, and pull the operating handle fully back to eject the round in the chamber. Do not obstruct the ejector port and keep fingers away from trigger and muzzle. With the operating handle fully held back, push up on the bolt stop and slowly release the operating handle, the bolt should stay open. Visually inspect the chamber to make sure it is empty. Pull back on the operating handle to release the bolt stop and release the operating handle to close the chamber. Push the remaining cartridges in the magazine forward and out.

Loading

To load, fill the magazine by pressing a cartridge downward on the front of the magazine follower, (or downward on the front of previously loaded cartridge) and then back towards the rear of the magazine. Continue loading until you have loaded the number of cartridges you wish to load, up to the normal magazine capacity of 27 rounds, unless noted differently on your magazine. Do not attempt to load your magazine with more than the specified number of rounds. Doing so can damage the magazine and can cause a feeding malfunction. Before inserting a loaded magazine always tap the back of the magazine against a hard surface two or three times in order to properly seat all the cartridges to the rear of the magazine.

With the firearm's safety engaged, hold the pistol in one hand with the muzzle pointing in a safe direction and with your finger off the trigger and outside the trigger guard. Insert the loaded magazine into the grip until it is locked in place. You may need to press and hold the magazine catch in to make insertion easier. Check to assure that the magazine is secure. Pull the operating handle back and release. This strips a round from the magazine and seats it in the barrel chamber.

If you wish to restore the magazine in your firearm to full capacity, press the magazine catch and remove the magazine to load the missing round. Remember to keep the safety engaged and your pistol pointed in a safe direction under all conditions and always keep your finger off the trigger and outside the trigger guard until ready to fire. Never insert a live cartridge by hand into the chamber and slam the bolt closed, doing so could cause the round to discharge.

DISASSEMBLY

NOTE: Disassembly can be performed with only a small screwdriver or a small punch. None of the screws on the pistol should ever need to be removed for general maintenance.

Bolt Removal

Remove the magazine and unload your firearm. Cycle the operating handle to be sure that there is no round in the chamber. Make sure

the bolt is in the forward position and the safety is engaged.

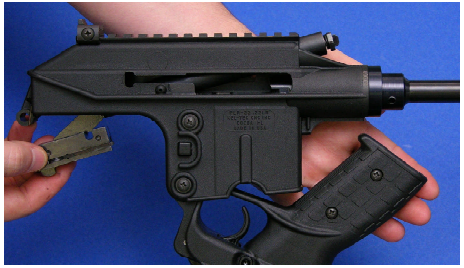
CAUTION: Some accessories that are mounted to the picatinny rail on the top of the receiver may interfere with the disassembly of the firearm. It is advisable to remove any scopes or other devices mounted to the rail before proceeding with disassembly.

With a screwdriver or other pointed object push out and remove the assembly pin. Rotate the grip down and forward. Reach into the rear of the receiver with your finger and pull out the buffer. Grab the recoil spring tube, pull it towards the muzzle and twist it 1/4 turn so

that the locking tab on the recoil spring tube points towards the top of the firearm, it should slide into the receiver about 1/4 inch as you release the recoil spring tube. Slowly pull back on the operating handle, the recoil spring tube should also move back and there should not be any spring pressure felt. If the tube is stuck, push it into the reciever by hand. Pull the operationg handle all the way back and push it down into the operating handle removal cutout in the receiver. The operating handle should now be able to be pulled straight out of the bolt. After the operating handle is removed the bolt assembly can now be guided out of the bottom of the receiver.

Disassembly of the bolt is not recommended, several springs are under tension and further disassembly is not necessary for general maintenance. The bolt can be cleaned and re-lubed without further disassembly.

NOTE: It is not recommended that you disassemble the grip of the PLR-22 or stock of the SU-22; the hammer spring is constantly under tension and can easily injure you or others.

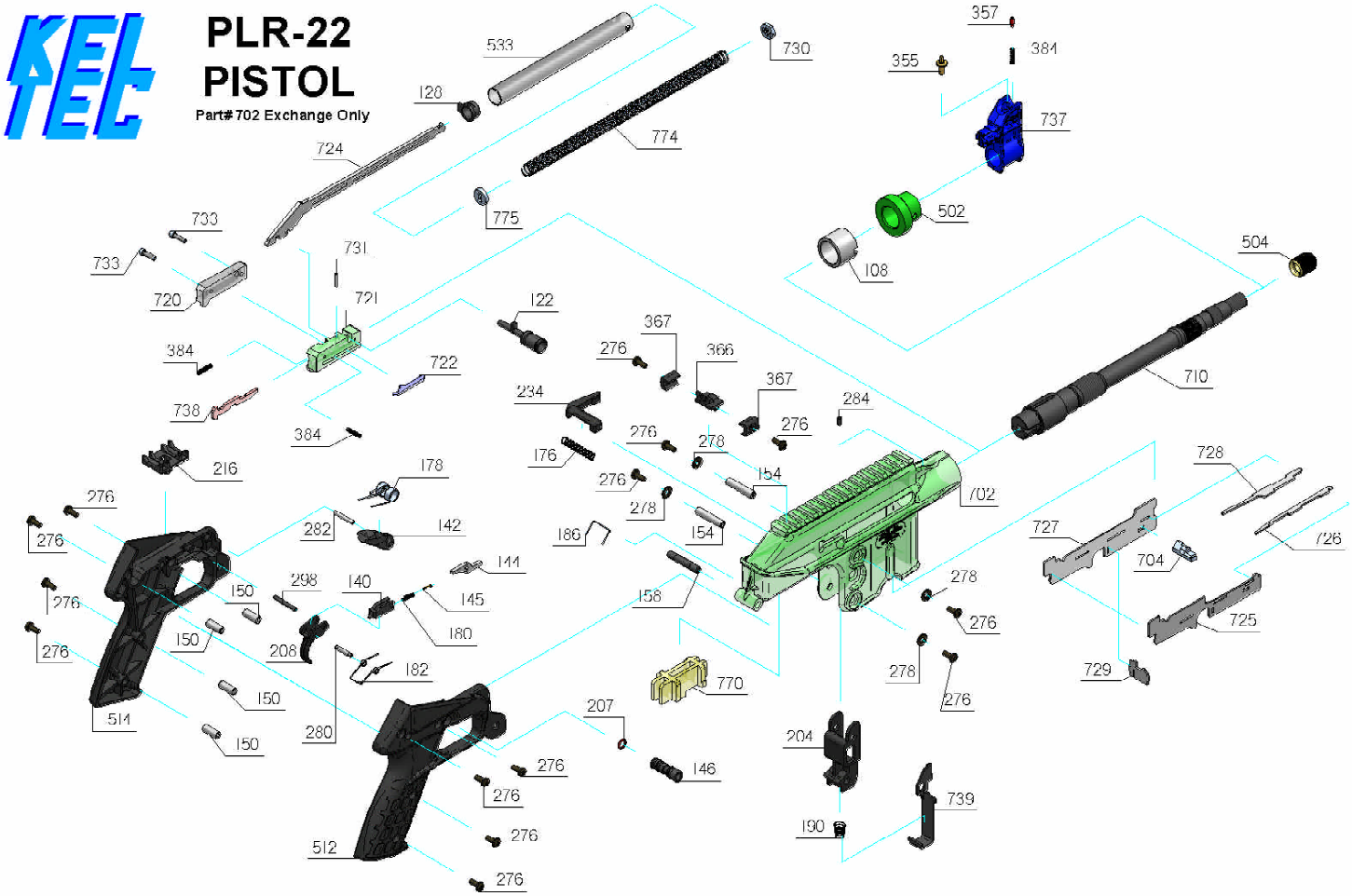


ASSEMBLY

With the grip folded, rest the firearm on its left side. Take the bolt assembly and twist the recoil spring tube so that the lock tab is at the top of the bolt assembly. Insert the bolt assembly from the rear of the receiver, pointing the recoil spring tube thru the hole above the barrel, be sure to keep the lock tab on the recoil spring tube pointing up as you insert it. Align the operating handle hole in the bolt with the cut-out in the receiver and insert the operating handle. Push the bolt up slightly so that the operating handle aligns with the slot for it and the recoil spring tube is parallel with the barrel of the firearm.

PLR-22 PISTOL

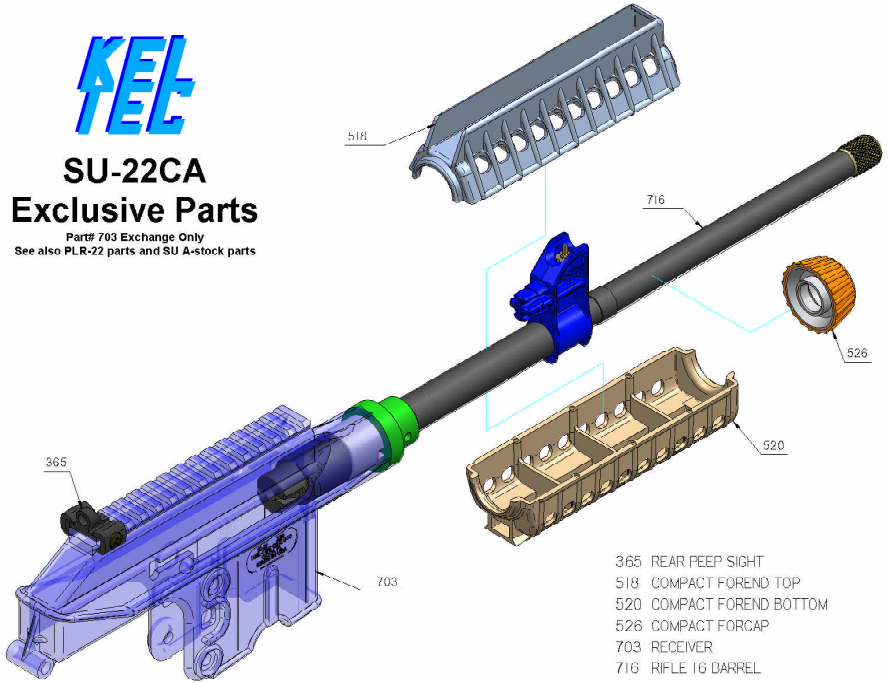
Part# 702 Exchange Only



108	BARREL RETAINER	366	REAR OPEN SIGHT
122	OPERATING HANDLE	367	REAR SIGHT ADJUSTER
128	RECOIL SPRING CATCH	384	FRONT SIGHT DETENT PIN SPRING
140	TRIGGER BLOCK	502	COMPACT FOREND BARREL NUT
142	HAMMER	504	LONG THREAD PROTECTOR
144	SEAR	512	PISTOL GRIP RIGHT
145	SEAR SPRING PIN	514	PISTOL GRIP LEFT
146	SAFETY	533	PISTOL RECOIL SPRING TUBE
150	STOCK SPACER-16	702	RECEIVER
154	SPACER-29	704	FEEDRAMP
158	ASSEMBLY PIN	710	PISTOL 10 BARREL
176	MAG CATCH SPRING	720	BOLT LEFT HALF
178	HAMMER SPRING	721	BOLT RIGHT HALF
180	SEAR SPRING	722	EXTRACTOR
182	TRIGGER SPRING	724	RECOIL SPRING GUIDE
186	STOCK PIN SPRING	725	RIGHT SIDE GUIDE PLATE
190	BOLT STOP SPRING	726	RIGHT SIDE GUIDE RAIL
204	MAGWELL	727	LEFT SIDE GUIDE PLATE
207	RED O'RING	728	LEFT SIDE EJECTOR RAIL
208	TRIGGER	729	MID SUPPORT PLATE
216	RECEIVER SPREADER	730	RECOIL SPRING LOCK BUTTON
234	MAG CATCH	731	EXTRACTOR AXIS
276	RECEIVER SCREW	733	BOLT SCREW
278	RECEIVER WASHER	735	MAGAZINE
280	SEAR PIN	737	FRONT SIGHT BLOCK
282	HAMMER AXIS	738	FIRING PIN
284	BARREL EXTENSION PIN	739	BOLT STOP
298	TRIGGER AXIS	770	BUFFER
355	FRONT SIGHT POST	774	RECOIL SPRING
357	FRONT SIGHT DETENT PIN	775	RECOIL SPRING WASHER

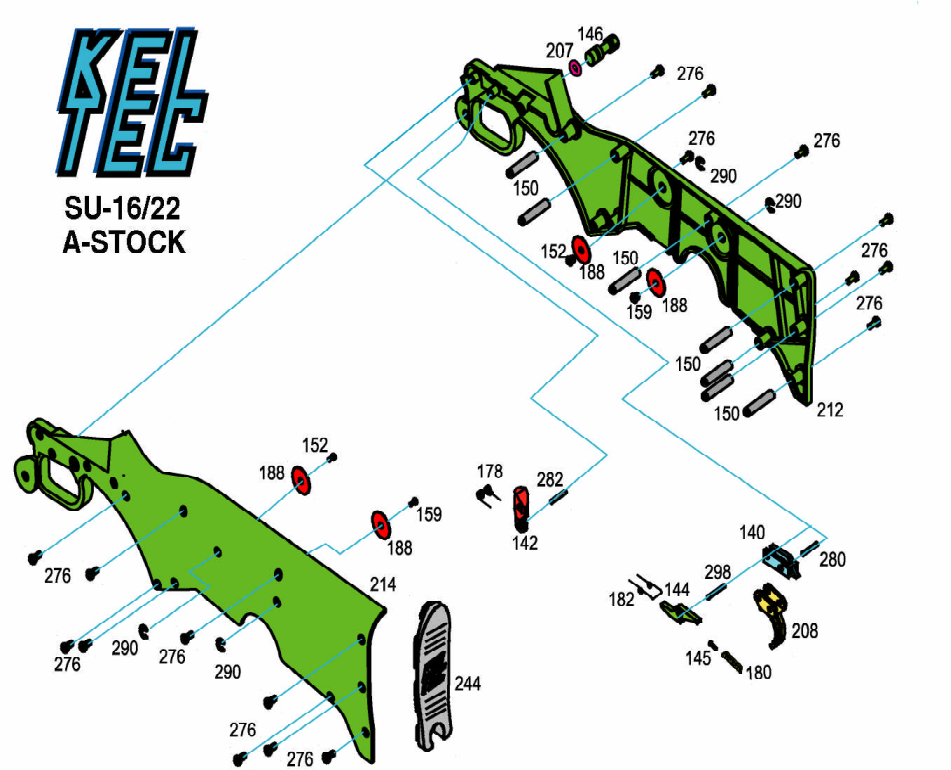
SU-22CA
Exclusive Parts

Part# 703 Exchange Only
See also PLR-22 parts and SU A-stock parts



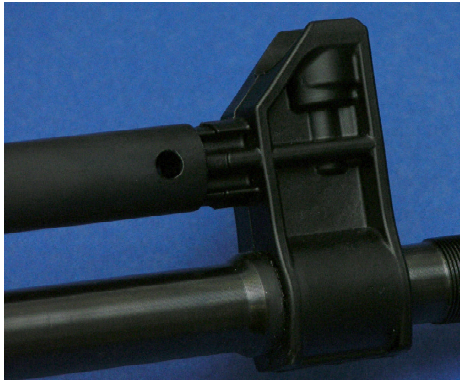
365 REAR PEEP SIGHT
518 COMPACT FOREND TOP
520 COMPACT FOREND BOTTOM
526 COMPACT FORCAP
703 RECEIVER
716 RIFLE 16 BARREL

SU-16/22
A-STOCK



140-TRIGGER BLOCK
142-HAMMER
144-SEAR
145-SEAR SPRING PIN
146-SAFETY
150-SPACER-16
152-MAG SNAP PIN-SHORT
159-MAG SNAP PIN-LONG
178-HAMMER SPRING
180-SEAR SPRING
182-TRIGGER SPRING
188-MAGAZINE SNAP SPRING
207-RED O'RING
208-TRIGGER
212-STOCK-RIGHT
214-STOCK-LEFT
216-RECEIVER SPACER
244-RECOIL PAD
276-RECEIVER SCREW
280-SEAR PIN
282-HAMMER AXIS
290-MAG SNAP E-RING
298-TRIGGER AXIS

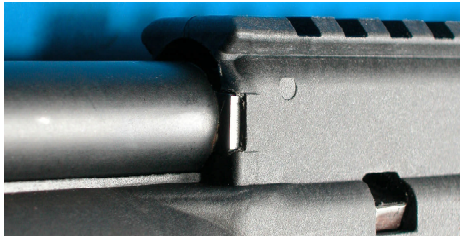
WARNING: If the recoil spring tube is not parallel with the barrel of the firearm the bolt assembly is not installed correctly. Remove the bolt assembly and install it again paying close attention to the alignment of the lock tab on the recoil spring tube as you insert the bolt assembly into the receiver.



Push the operating handle all the way forward, the recoil spring tube should line up with the protrusion on the front sight. Grip the recoil spring tube, pull it forward and twist it 1/4 turn so that the locking tab on the recoil spring tube goes into the receptacle on the left side of the receiver. The front of the recoil spring tube may catch on the recoil spring lock button, if this is the case push the front of the tube down or wiggle the bolt assembly forward and backwards by the operating handle. Insert the buffer into the back of the reciever, the narrower end goes between the metal guide plates.

DO NOT FORGET THE BUFFER, doing so may cause the bolt assembly to lock back behind the hammer and may damage the recoil spring.

Pull the operating handle back and forth to check that the bolt assembly moves freely, if it does not, take out the bolt assembly and check to make sure everything is installed correctly and nothing is damaged. Unfold the grip. Insert the assembly pin into the hole and press it in until it is flush with the outside of the grip.



SIGHT ADJUSTMENT

The amount of sight adjustment depends on the placement of the rear sight. If the sight is in the farthest forward slot on the picatinny rail, the firearm will have a different sight radius than if the sight is placed farthest rearward on the picatinny rail. The data given is for the sight in the rearmost position.

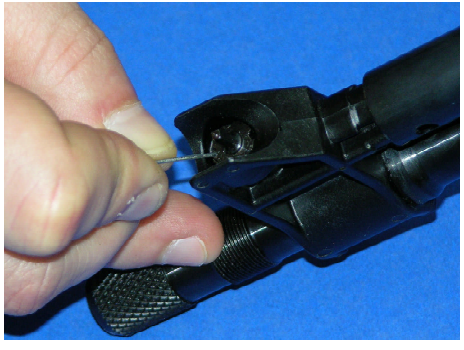
Use a phillips head screwdriver to adjust the windage with the two screws on the sides of the rear sight. Tighten the screw on the same side of the rear sight that you want to move the point of impact to. You will have to loosen the opposite side screw first. For example: to move the point of impact left 1/2 inch at 50 yards you would loosen (counter-clockwise) the right screw 1/8 turn and tighten (clock-wise) the left screw 1/8 turn.

For the front sight, use a small tipped tool, like a paper clip or an M-16 A2 style front sight tool (not included) to depress the detent pin and turn the sight post by hand. One click (1/4 turn) will change the point of impact 1 inche at 50 yards. Clockwise moves the point of impact up and counter-clockwise moves it down.

MAINTENANCE

Your fream is a precision instrument and to insure reliable function, it is necessary to follow a routine maintenance procedure. After firing your pistol, be sure to unload it following the procedure outlined in the section entitled “Unloading” before any cleaning or mainte-nance procedure.

CLEANING SOLVENT WARNING:
Never use automotive brake cleaner, or any solvent not designed for polymer firearms on the polymer parts of the firearm including, but not limited to, the buffer and magazine. Doing so will damage or destroy the parts and this abuse will not be covered by any warranty.



Always use polymer-safe solvents designed for firearms when cleaning polymer firearm parts.

Routine cleaning, after every shooting session:
Your firearm should be cleaned by brushing the barrel bore and chamber with a good powder- removing solvent and bore brush. Wipe the areas clean with patches or a swab. Using a small brush dipped in solvent, remove all deposits from around the breech of the barrel, bolt face, and chamber and adjacent areas which have been subjected to the action of powder or primer residue. Remove any residue on the frame with light brushing and a polymer safe solvent. After cleaning the entire gun, use a cloth to apply a light coating of high quality gun oil to all external surfaces and wipe clean.

Additional cleaning, after firing 500 to 1000 rounds:
Remove the bolt assembly as stated in the disassembly section of this manual. Thoroughly clean with solvent and a brush the bolt face and all sides of the bolt. Brush around the extractor and firing pin. Thoroughly dry all parts. Apply a light coat of oil to the exterior surfaces of the bolt and wipe off any excess. Apply a light coat of oil on the recoil spring guide and re-install the bolt assembly and firearm as stated in the assembly part of this manual. **DO NOT FORGET TO REINSTALL THE BUFFER.** Manually cycle the bolt back and forth to check the function of the firearm. If any parts are damaged or badly worn or the firearm does not work correctly the firearm should not be fired and should be returned to Kel-Tec for servicing immediately.

LUBRICATION WARNING:
Firing a firearm with oil, grease, or any other material even partially obstructing the bore may damage the pistol and injure the shooter and those nearby. Do *not* spray or apply lubricants directly on ammunition. If the powder charge of a cartridge is affected by the lubricant, it may not be ignited, but the energy from the primer may be sufficient to push the bullet into the bore where it may become lodged. Firing a subsequent bullet into the obstructed bore will damage the pistol and may injure the shooter and bystanders. *Use lubricants properly.* You are responsible for the proper care and maintenance of your firearm.

WARNING:
It is not recommended that you disassemble the grip or stock; the hammer spring is constantly under tension and can easily injure you or others. If the need arises to lubricate the trigger assembly do so through the access slot behind and in front of the hammer.

Service

Should your firearm require adjustment, or repair, it should be returned unloaded to the factory. Always remove any non factory accessories including scopes and muzzle devices before sending in for repairs. Kel-Tec CNC IND INC cannot be held responsible for lost or damaged accessories sent in with the firearm. In shipping the firearm, be sure to adhere to the following rules:

Individuals who wish to return the firearm for service can do so by shipping via UPS prepaid. No return authorization number is required.

Include a letter of instruction, full name, address, phone number, email and the gun's serial number. Retain a copy of the serial number for your records to use in tracking your repair. This will insure prompt service and handling once your pistol has been received. You will receive a quotation for anything other than warranty work. You will be notified of full charges and no work will commence before receiving your approval of our quotation if non-warranty work is necessary. Please see the warranty page at the end of this manual or contact Kel-Tec directly for more details. All quotations are payable by C.O.D., VISA, M.C. or money orders only. No personal checks accepted.

WARRANTY

This warranty is granted by Kel-Tec CNC Industries, Inc. P.O. Box 236009, Cocoa, FL 32923. This lifetime warranty is effective from the date of purchase and applies to the original owner of a Kel-Tec firearm.

Kel-Tec firearms are warranted to be free from defects in material and workmanship. Any such defects of which Kel-Tec receives written notice by the original owner, will be remedied by Kel-Tec without charge within a reasonable time after such notification and delivery of the product as provided below.

Warranty claims (in writing) and the gun concerned should be delivered (transportation charges pre-paid) to:

Kel-Tec CNC, Inc
Service Department
1475 Cox Road
Cocoa, FL 32926.

No return authorization number is required. In addition, a copy of a bill of sale in the owner's name, or a copy of ATF Form 4473, indicating date of purchase must be included.

In order to expedite service, warranty claims should state the model and serial number of the gun concerned and a description of the difficulty experienced. It is recommended that shipments be insured by the owner, since Kel-Tec will accept no responsibility for loss or damage in transit.

Transportation and insurance charges for return to owner will be paid by Kel-Tec if the claim is covered by the warranty.

Under no circumstances shall Kel-Tec be responsible for incidental or consequential damages with respect to economic loss or injury or property damage, whether as a result of breach of express or implied warranty, negligence or otherwise. Some states do not allow the exclusion or limitation or incidental or consequential damages, so the above limitation or exclusion may not apply to you.

Kel-Tec will not be responsible for defects resulting from careless handling, unauthorized adjustments or modifications, defective or improper ammunition, corrosion, neglect, fire damage, water damage, theft, abuse, ordinary wear and tear, or unreasonable use.

Notes